

Date: Friday, 9/15/2006 11:58:53 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: FRAME WELDMENT		
Job Number	: 28614					
Estimate Number	: 11202					
P.O. Number	: N/A			Part Number	: D3330041	
This Issue	: 9/15/2006		S.O. No. : N/A	Drawing Number	: D3330 REV B1	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: N/A	Type	LARGE FAB ASSY	Drawing Revision	: B1	
Previous Run	: 28613			Material	: N/A	
Written By	: <u>KJ/JLM</u>			Due Date	: 10/5/2006	
Checked & Approved By	: <u>KJ/JLM</u>			Qty:	2 Um: Each	
Comment	: Est. A05.013 New Issue KJ/JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D33301	Panel	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)	(2)
		Panel	
		Pick:	
✓	Qty Part Number Description Batch		
	1 D3330-1 Panel	B22258	PCL 06-10-30
2.0	D33302	Panel	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)	(2)
		Panel	
		Pick:	
✓	Qty Part Number Description Batch		
	1 D3330-2 Panel	B28624	PCL 06-10-30
3.0	D33303	Panel	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)	(2)
		Panel	
		Pick:	
✓	Qty Part Number Description Batch		
	1 D3330-3 Panel	B28625	PCL 06-10-30
4.0	D33305	Rail	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)	(2)
		Rail	
		Pick:	
✓	Qty Part Number Description Batch		
	1 D3330-5 Panel	B28626	PCL 06-10-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/15/2006 11:58:53 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FRAME WELDMENT

Job Number: 28614

Part Number: D3330041

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 D33307 Panel



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

(2)

Panel

Pick:

Qty Part Number Description Batch
1 D3330-7 Panel B28627

CPL 06-10-30

6.0 D33309 Top Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

(2)

Top Plate

Pick:

Qty Part Number Description Batch
1 D3330-9 Panel B28628

CPL 06-10-30

7.0 D333011 Long Pin Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

(2)

Long Pin Bracket

Pick:

Qty Part Number Description Batch
1 D3330-11 Long Pin Bracket B23590

CPL 06-10-30

8.0 D333013 Short Pin Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

(2)

Short Pin Bracket

Pick:

Qty Part Number Description Batch
1 D3330-13 Short Pin Bracket B23044

CPL 06-10-30

9.0 D333015 Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

(2)

Handle

Pick:

Qty Part Number Description Batch
1 D3330-15 Handle B28623

CPL 06-10-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/15/2006 11:58:53 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FRAME WELDMENT

Job Number: 28614

Part Number: D3330041

Job Number:



Seq. #: Machine Or Operation:

Description :

10.0 D333017 Handle Socket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Handle Socket

Pick:

✓ Qty Part Number Description Batch
1 D3330-17 Handle Socket B23047

CPL 06-10-30

11.0 D333019 Handle Rim



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Handle Rim

Pick:

✓ Qty Part Number Description Batch
1 D3330-19 Handle Rim B23048

CPL 06-10-30

12.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Assemble and Weld as per Dwg Dwg D3330 using D3330-041T1

Identify as D3330-041

CPL 06-10-31

13.0 QC5/9 WELD INSPECTION



Comment: WELD INSPECTION

106/10/01

14.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

AM 06/11/06

15.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

106/11/07

16.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST07

Rec'd 10/07 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 08/11/07
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/15/2006 11:58:54 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FRAME WELDMENT

Job Number: 28614

Part Number: D3330041

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

QC21

FINAL INSPECTION/W/O RELEASE



(2)

Comment: FINAL INSPECTION/W/O RELEASE

9/15/1107

Job Completion



C 206 1107

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

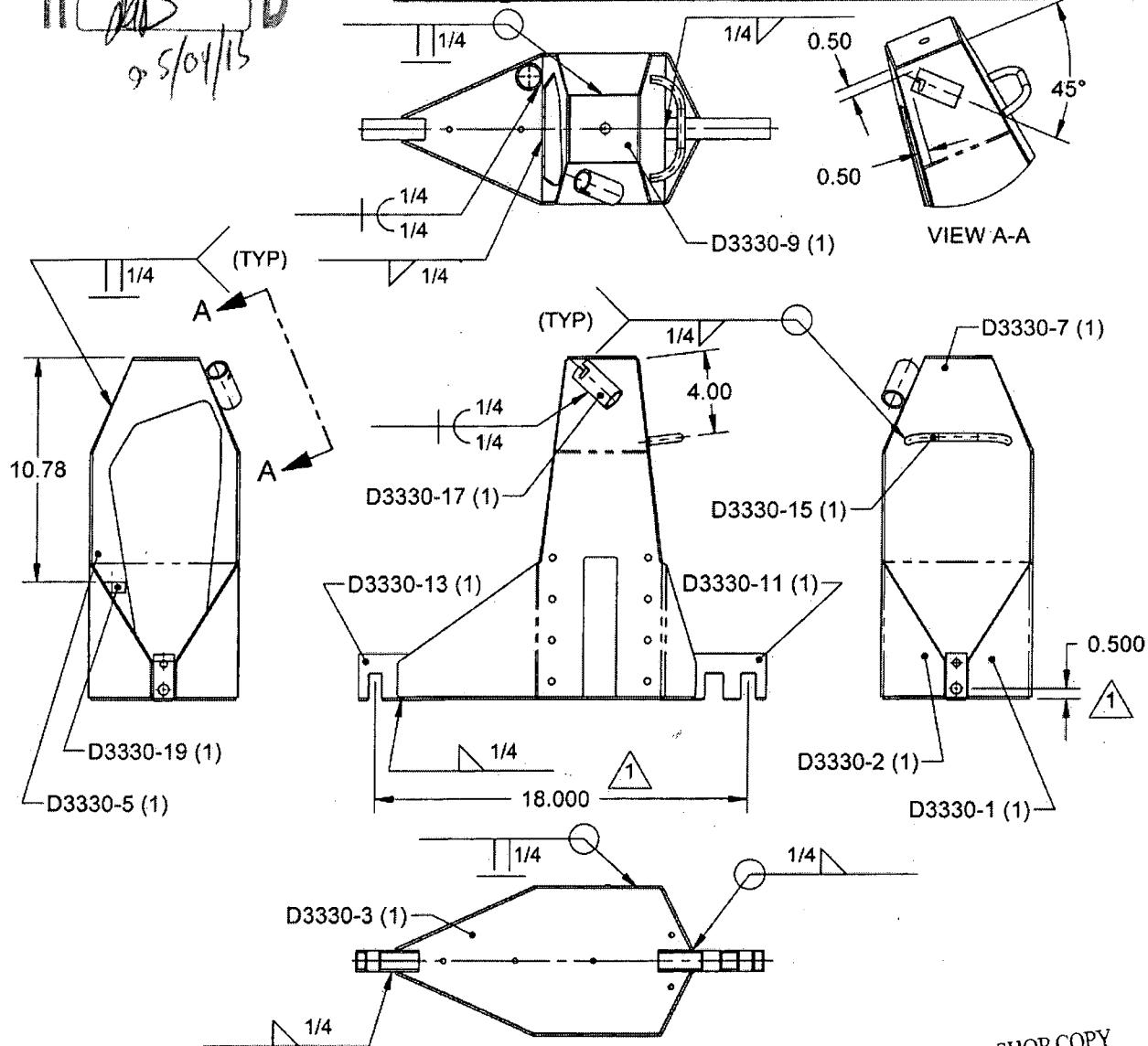
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>13</i>	DRAWN BY <i>13</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PF</i>	APPROVED <i>K</i>	DRAWING NO. D3330	REV. B SHEET 1 OF 9
DATE 05.02.26		TITLE FRAME WELDMENT	SCALE 1:8
A 04.12.16	NEW ISSUE		
B 05.02.26	REDESIGN		
B1 05.07.04	ADD 1.605 DIM.		

RELEASED
S/04/15



D3330-041 FRAME WELDMENT

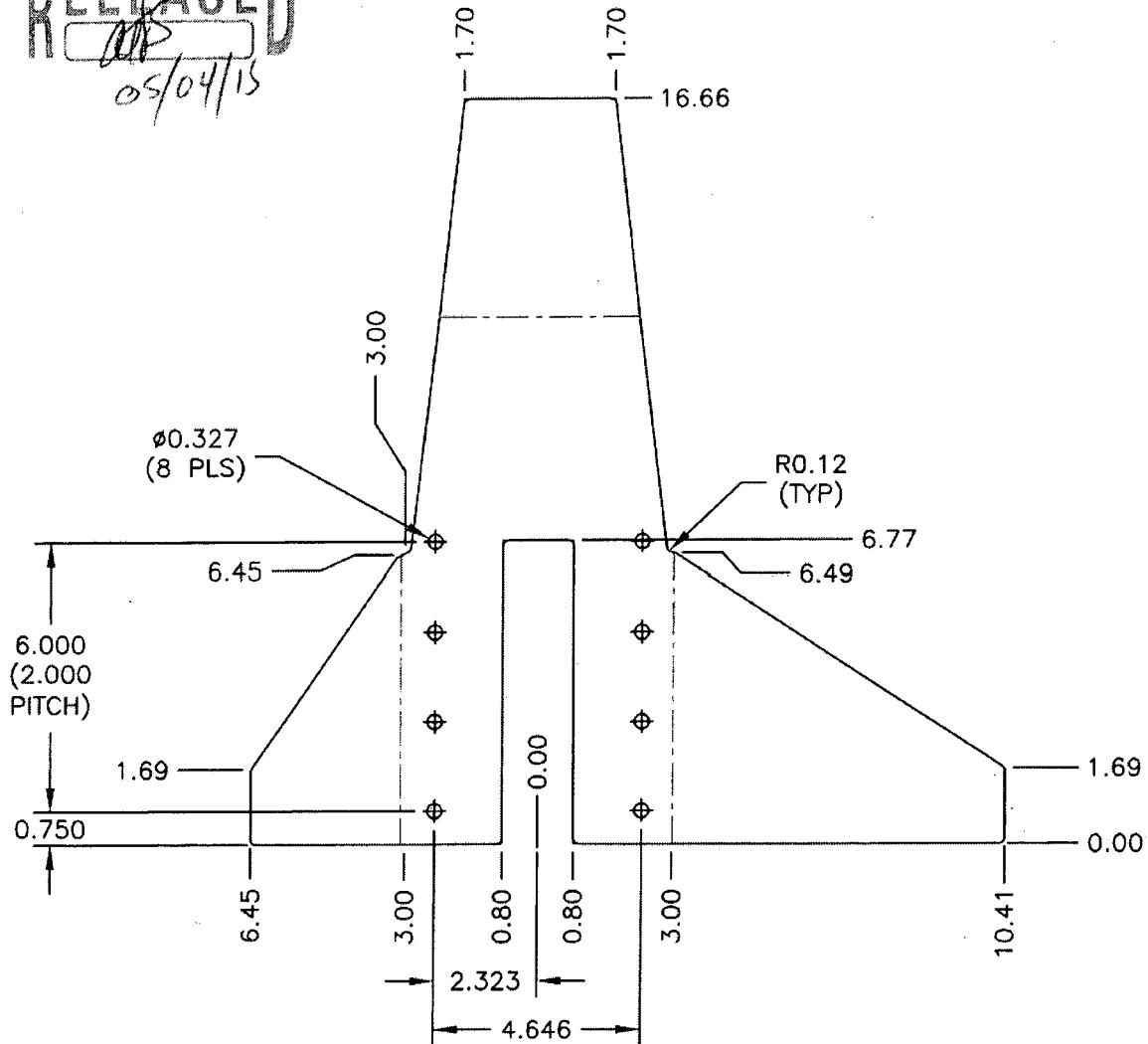
NOTES:

- 1) POSITION PARTS AS PER JIG D3330-041T1
- 2) WELD PER QSI 004
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
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NO. *28614*

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DATE	05.02.26	D3330	SHEET 2 OF 9
		TITLE	SCALE
		FRAME WELDMENT	1:4

RELEASED
*DP
05/04/15***D3330-1 PANEL****NOTES:**

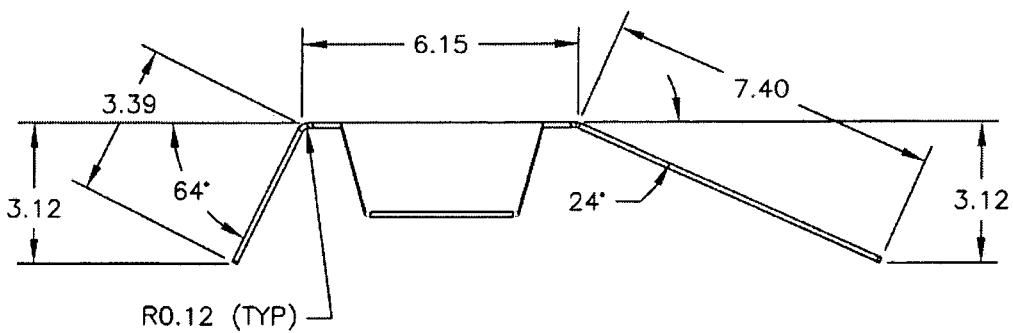
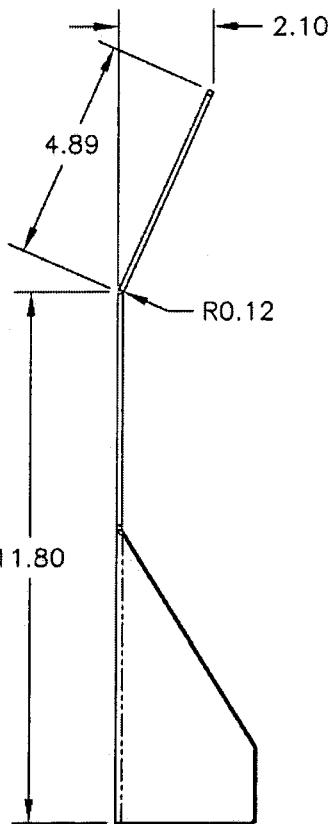
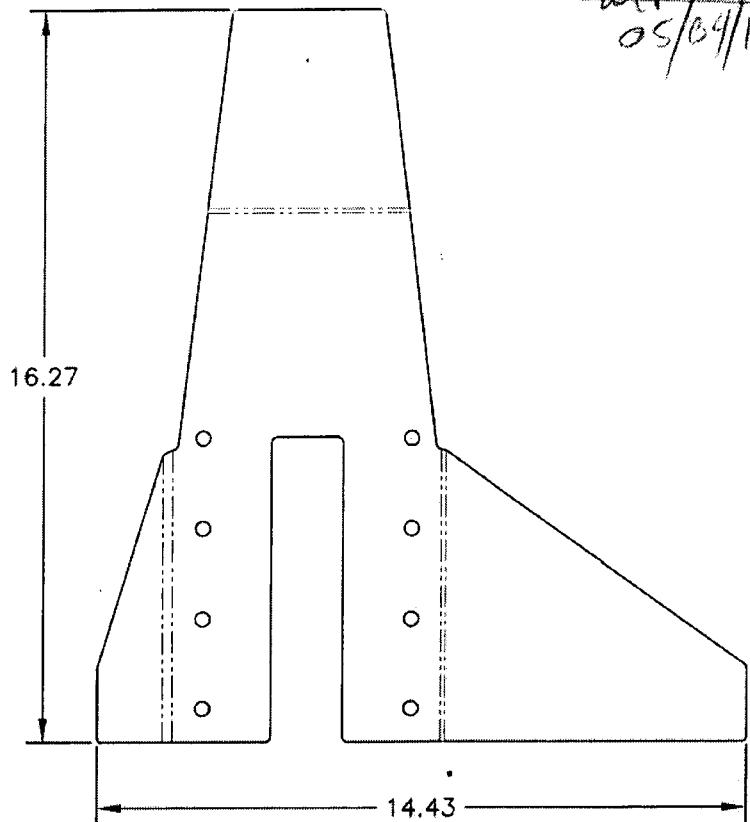
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40.21 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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WITHOUT NOTICE
WORK ORDER
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		D3330	SHEET 3 OF 9
DATE	TITLE	SCALE	
05.02.26	FRAME WELDMENT	1:4	

RELEASED
05/04/15



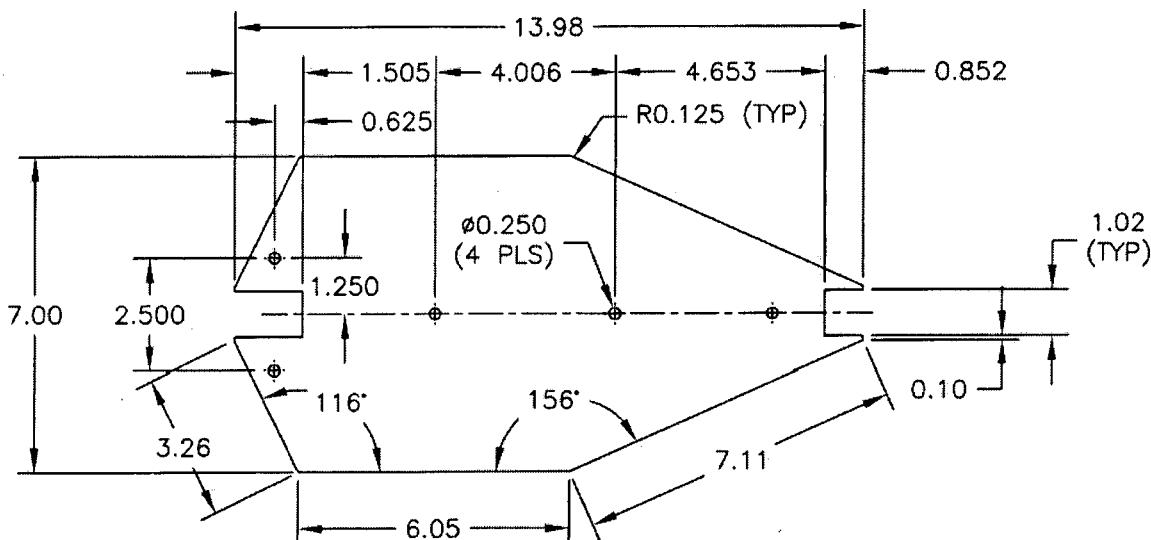
D3330-1 BEND DETAIL (SHOWN)
BEND D3330-2 (OPPOSITE)

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WITHOUT NOTICE
WORK ORDER
NO. 28614

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DATE 05.02.26		TITLE FRAME WELDMENT	SCALE 1:4

RELEASED
MP
05/07/15

**D3330-3 PLATE****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21 UNCONTROLLED COPY
38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
SUBJECT TO AMENDMENT
WITHOUT NOTICE
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY
RETURN TO
ENGINEERING

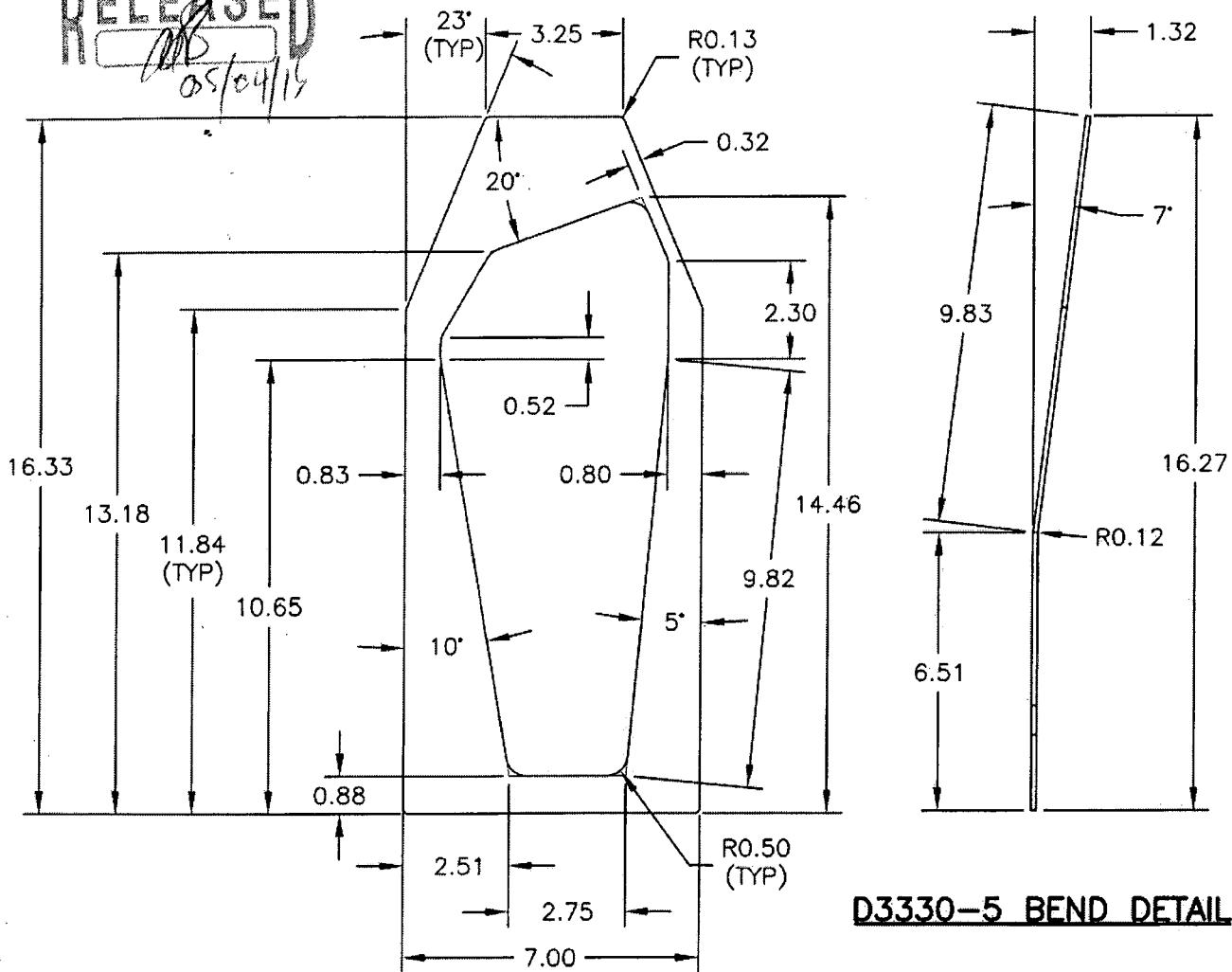
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *28614*



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CHECKED	APPROVED	DRAWING NO.	REV. B
		D3330	SHEET 5 OF 9

DATE 05.02.26 TITLE FRAME WELDMENT SCALE 1:4

RELEASED
05/04/11



D3330-5 BEND DETAIL

FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, RETURN TO 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
NO. 28614

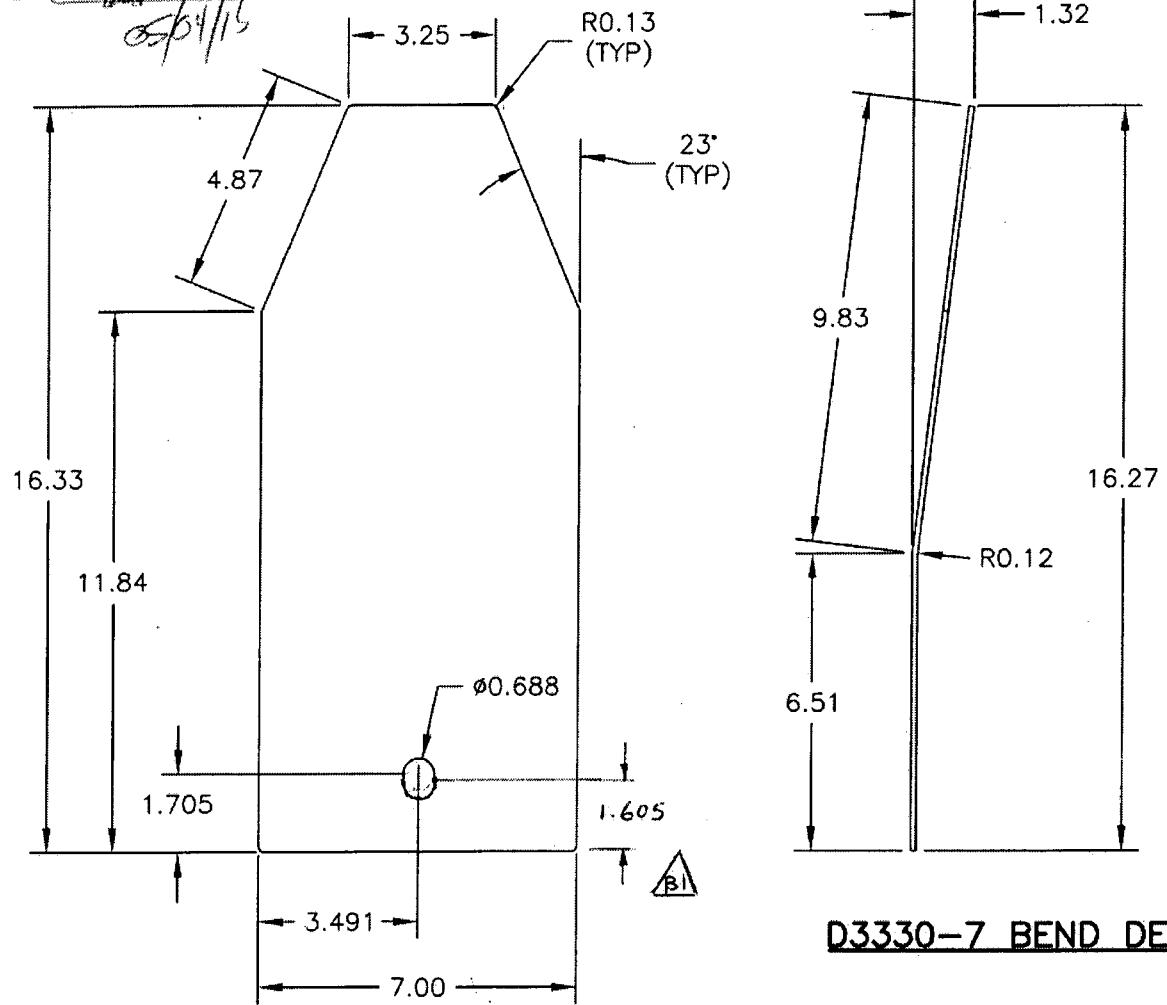
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3330	REV. B SHEET 6 OF 9
DATE 05.02.26		TITLE FRAME ASSEMBLY	SCALE 1:4

RELEASED
[Signature]
5/5/13



FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125" THICK)
ENGINEERING COPIED COPY
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED SUBJECT TO AMENDMENT
- 3) ALL DIMENSIONS ARE IN INCHES WITHOUT NOTICE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010 WORK ORDER

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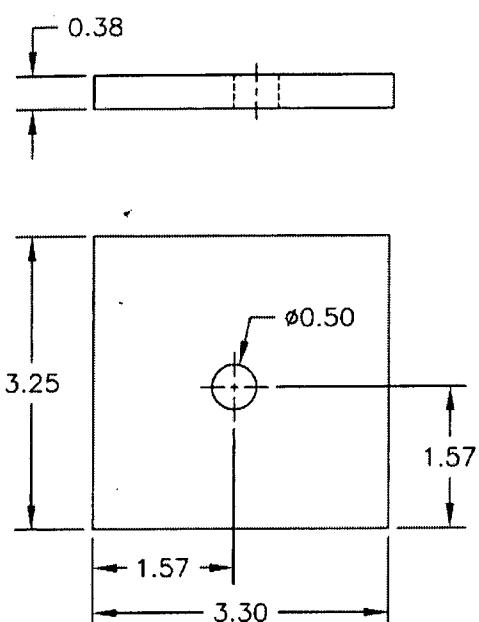
NO. *28614*

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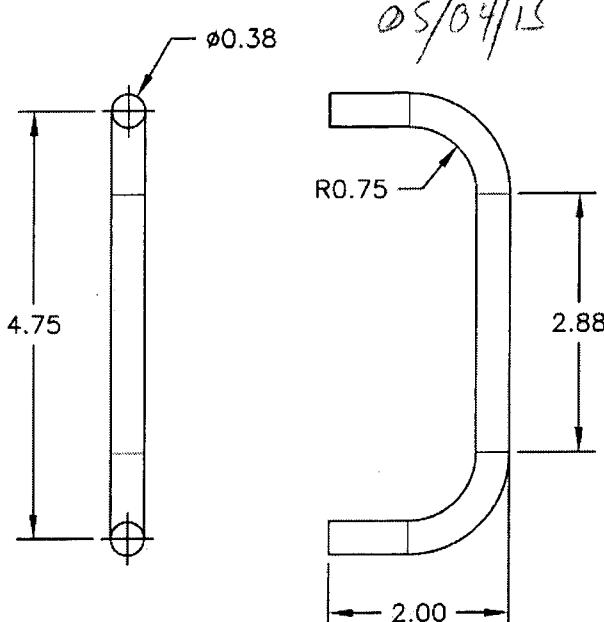
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CHECKED	APPROVED	DRAWING NO.	REV. B SHEET 7 OF 9
DATE	05.02.26	TITLE	SCALE 1:2



△ D3330-9 TOP PLATE



△ D3330-15 HANDLE

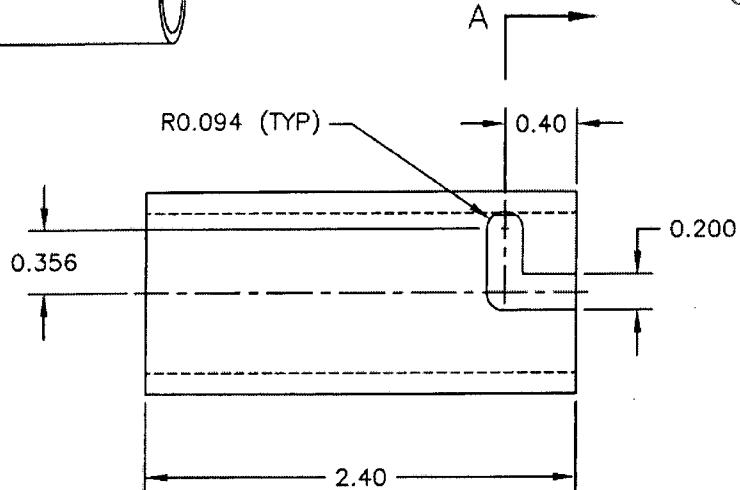
NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008, 0.375 STEEL
(REF. DART SPEC. M1010-B0.375x3.500)
- 2) MATERIAL: AISI 1018-1025 ROUND BAR PER MIL-S-7097
(REF. DART SPEC. M1018-R0.375)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

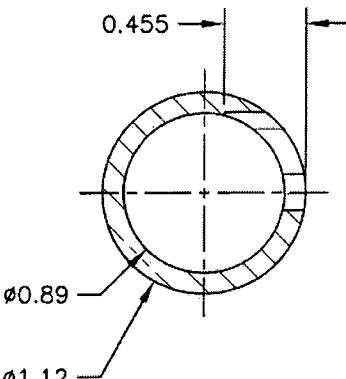
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WORK ORDER
NO. 28614

DART

DESIGN <i>13</i>	DRAWN BY <i>JP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PF</i>	APPROVED <i>WWD</i>	DRAWING NO. D3330	REV. B SHEET 8 OF 9
DATE 05.02.26		TITLE FRAME WELDMENT	SCALE 1:1

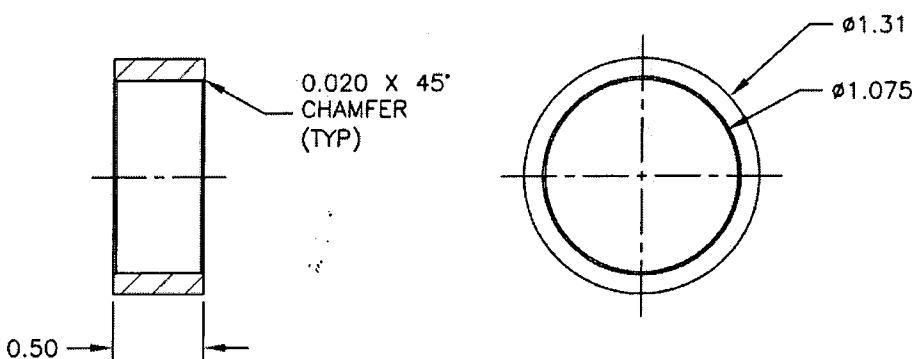


RELEASED
MP 05/04/15



SECTION A-A

D3330-17 HANDLE SOCKET



D3330-19 HANDLE RIM

NOTES:

- 1) MATERIAL: 1010-1025 ROUND BAR STEEL PER MILL-S-7097 UNCONTROLLED COPY
(REF. DART SPEC. M1025TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED SUBJECT TO AMENDMENT
- 3) ALL DIMENSIONS ARE INCHES WITHOUT NOTICE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010 WORK ORDER
NO. *28614*

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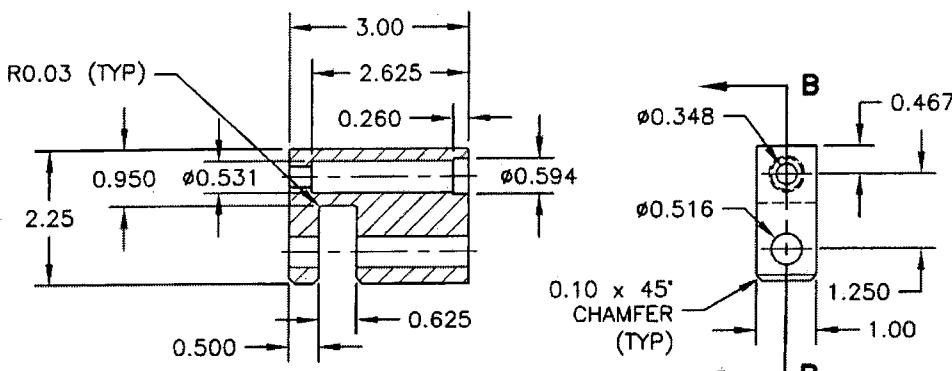
WORK ORDER

NO. *28614*

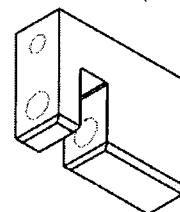
DART

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CHECKED F	APPROVED JLB	DRAWING NO. D3330	
DATE 05.02.26	TITLE FRAME WELDMENT	REV. B	SHEET 9 OF 9

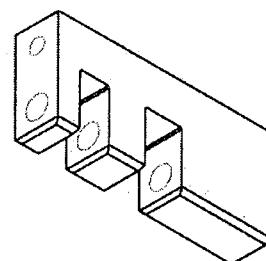
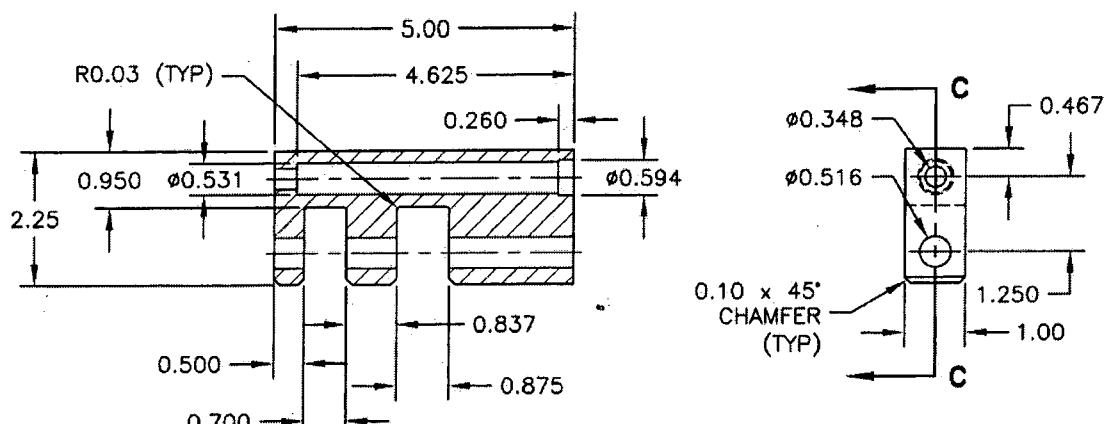
1:3



RELEASED
APP
05/04/15.



D3330-13 SHORT PIN BRACKET



D3330-11 LONG PIN BRACKET

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 1.000 THICK STEEL
- (REF. DART SPEC. M1010-B1.000x02.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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WORK ORDER

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